

Date: Tuesday, 4/15/2008 2:35:35 PM
 User: Chantal Lavoie

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: CAP		
Job Number	: 38605		Part Number	: D2965		
Estimate Number	: 11627		Drawing Number	: D2965 REV B		
P.O. Number	:		Project Number	: N/A		
This Issue	: 4/15/2008		Drawing Revision	: B		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 4/16/2008		
Previous Run	: 36033		Qty:	4 Um: Each		
Written By	:					
Checked & Approved By	:					
Comment	: Est: A 00.05.31 New Issue EC					
	: Est Rev:Added Turning as per Rev B 06-12-15 JLM					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	PG	PURCHASING	
		Comment: PURCHASING	
		Issue P/O.	
		Cast per Dwg D2965	
		Material Release Note Required	
2.0	D2965P	Cap	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Cap	
3.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1	
		Recieve & Inspect for Transit Damage	
		Ensure Material Release Note is attached	
4.0	QC6	DIMENSIONAL CHECK	
		Comment: DIMENSIONAL CHECK	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	
		Drill as per Dwg D2965 with DT8538	
		Deburr and Tumble	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0 QC6

DIMENSIONAL CHECK



N/A



Comment: DIMENSIONAL CHECK

7.0

POWDER COATING

POWDER COATING



M107550



Comment: POWDER COATING

Mask as per Dwg D2965

Powder To match Skidtube(Ref: 4.3.5.x) as per QSI 005 4.3

FOL 08/04/15 (4)

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

M-A 08/04/16

9.0 ALS71032225

INSERT



X



(4X)

Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

INSERT

Pick:

Qty	Part Number	Description	Batch
2	ALS7-1032-225 or AKS7-1032-225 or ALS4-1032-225 or AKS4-1032-225	Insert	M100621

M-A 08/04/16

10.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(4X)

Comment: SMALL & MEDIUM FAB RESOURCE 1

Install Inserts as per Dwg D2965

M-A 08/04/16

11.0 QC5

INSPECT WORK TO CURRENT STEP



(4)

Comment: INSPECT WORK TO CURRENT STEP

M-A 08/04/16

12.0 PACKAGING 1

PACKAGING RESOURCE #1



(4X)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

N/A M-A 08/04/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:	Machine Or Operation:	Description :
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13.0

QC21

FINAL INSPECTION/W/O RELEASE



08/04/2011
JL

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



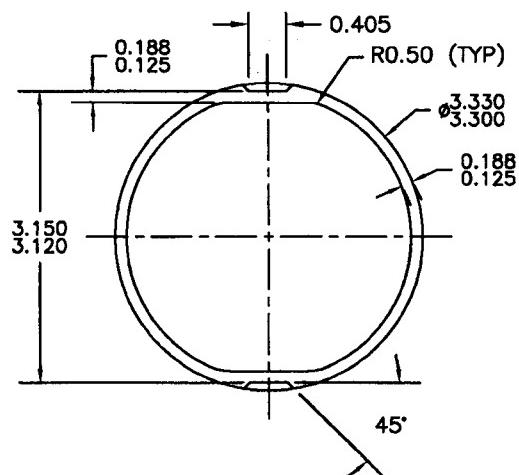
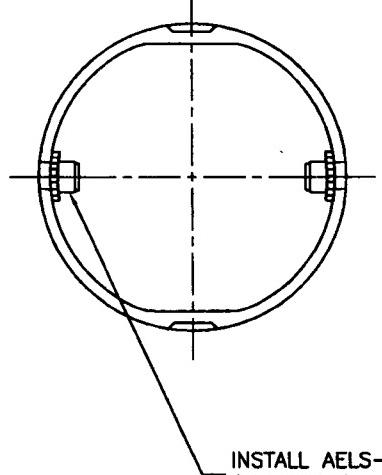
u 08-04-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

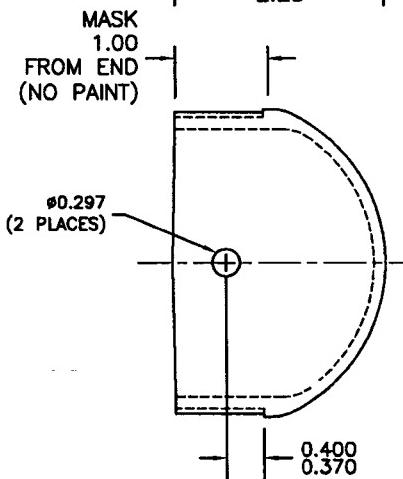
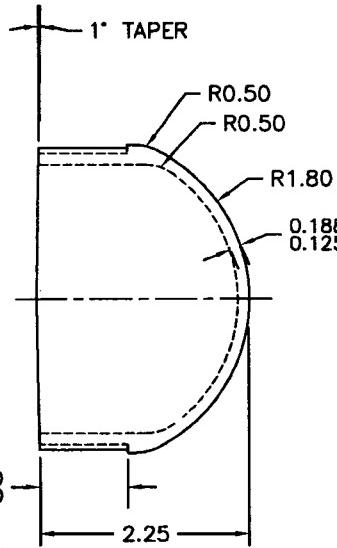
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DARTD2965 CASTING DETAILD2965 FINISH DETAILD2965 CAP

- 1) MATERIAL: CAST ALUMINUM ALLOY A356.2 (F)
- 2) FINISH: POWDER COAT PER QSI 005 4.3 TO MATCH REST OF SKIDTUBE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE INCHES



DESIGN P/H	DRAWN BY P/H	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2965
DATE 06.11.01	SCALE 1:2	SHEET 1 OF 2
A 00.02.24	NEW ISSUE	TITLE CAP
B 06.11.01	ADD - 3 CAP	

RELEASED
06.12.12 *[Signature]*

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